

Work Order ID 151714***151714***

Page 1

Friday, October 07, 2016 2:33:25 PM

Item ID: D4092-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Maintenance Step

Start Date: 9/29/2016

Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/7/2016

Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

16-10-11

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4092

C

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

16

Ø

DAS
20
9-89

16-11-02

110

0.17

110

HAAS 1

Memo

0.62

HAAS CNC vertical machine #1

Mill as per Dwg and Folio FA935

Dwg Rev: C

Folio rev: E A

Deburr

****Grind flush transition machining mark after machining bottom of extrusion,
see detail A.****

16

Ø

DAS
44
9-89

16-11-05

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Page 2

Item ID: D4092-1 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 10/7/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.02				16	Ø		DAS 44 9-89 16-11-05
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.04				16	Ø		DAS 49 9-8 16/11/06
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.18				(x16)	Ø		2016/11/09 BEB

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155 *155* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>M135819</u> Memo	0.00 0.26				<u>(16)</u>	<u>0</u>		<u>2016/11/11</u> <u>BEB</u>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02				<u>16</u>			<u>DAS</u> <u>38</u> <u>9-89</u> <u>NOV 18 2016</u>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>S450</u> Memo	0.00 0.02				<u>DAS</u> <u>6</u> <u>9-89</u>			<u>NOV 22 2016</u>

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Reference:

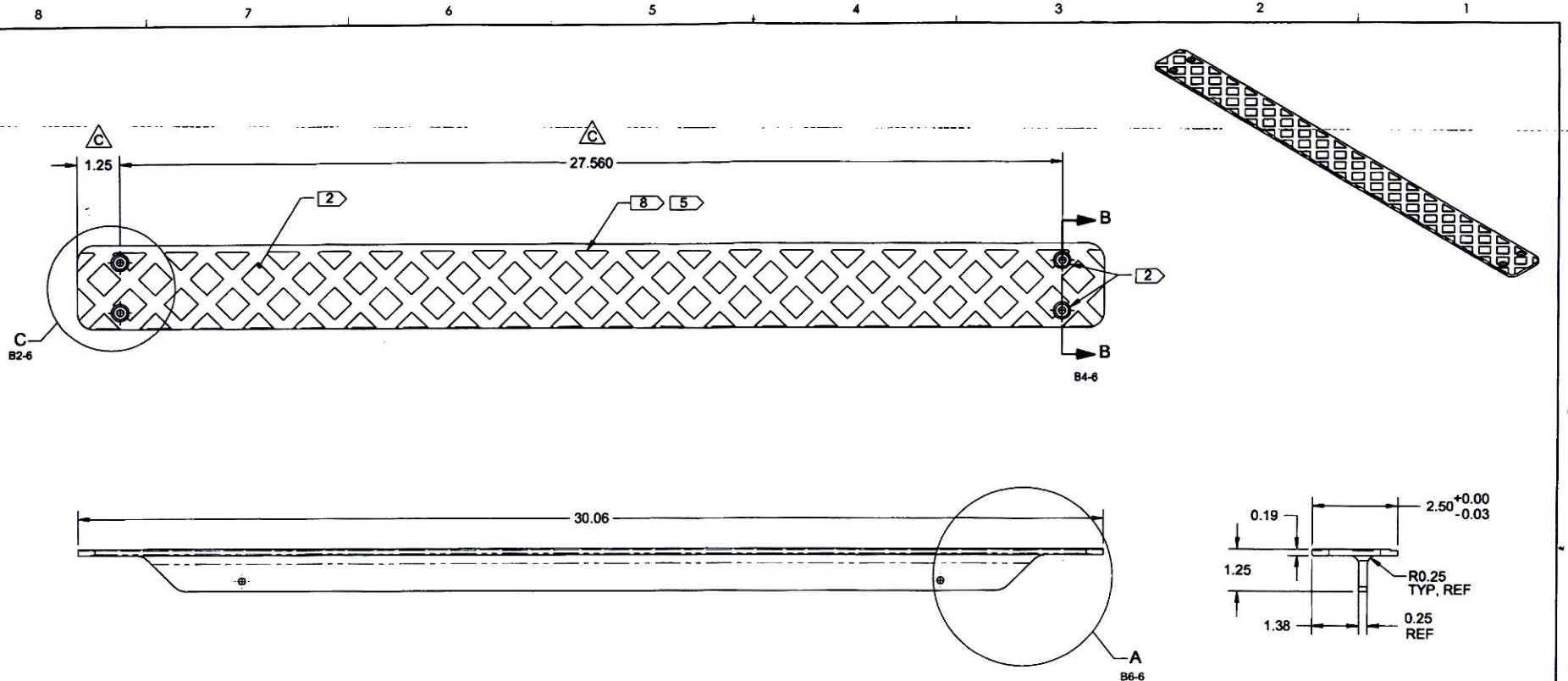
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89

NOV 22 2016

47.583'



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155714
16-10-11

APPROVED

DESIGN	VS
DRAWN	VS
CHECKED	RF
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	15.03.09

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. D4092	REV. C
TITLE MAINTENANCE STEP ASSY	SCALE NTS

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2015-09-21

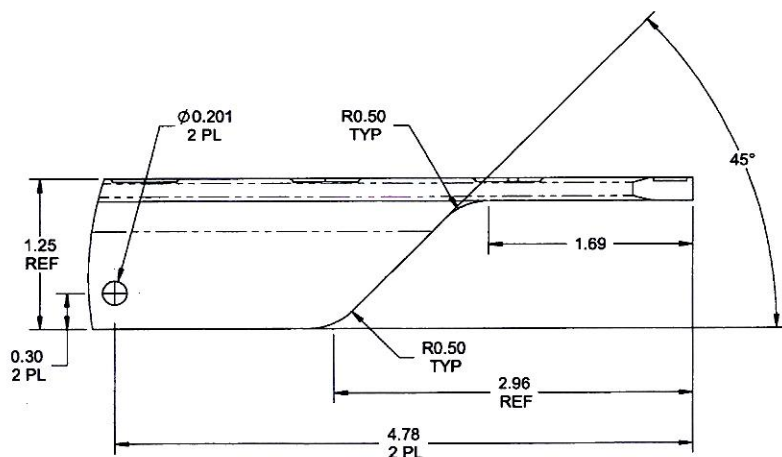
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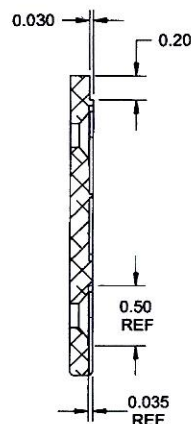
C

B

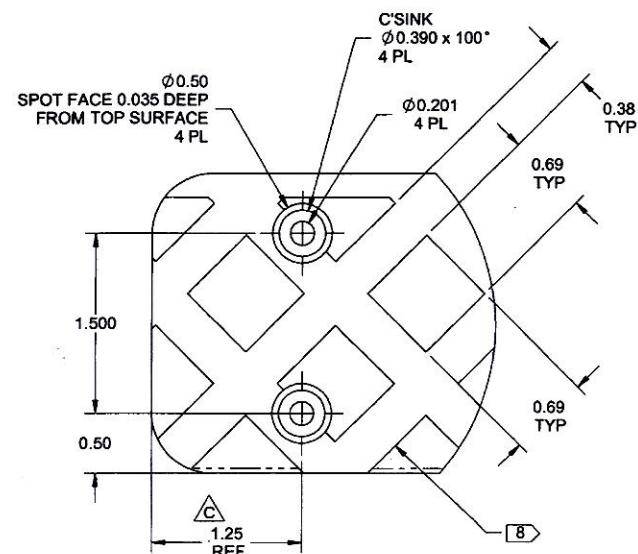
A



DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

RELEASED
2015-09-21

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	DRAWN	VS		
	CHECKED	RF	DRAWING NO.	REV. C
	MFG. APPR.	JLM	D4092	SHEET 6 OF 8
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8 7 6 5 4 3 2 1